

Work Order ID 56644

Wednesday, March 03, 2010 11:06:45 AM

Page 1

Item ID: D3224-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Frame

Start Date: 3/3/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 3/4/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan: *MF*Date: *10-3-3*

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

170

0.00



Packaging

Memo

0.00

Packaging

PULL FROM STOCK D3224-1 X 4
B47759

RE-IDENTIFY AS D3224-3 UNDER NEW BATCH NUMBER

10-3-3 SD (4x)

180

0.00



QC

QC4- 100% Inspect kits for completeness

Memo

0.00

Quality Control

*S 10607/07**(4x)*

190

0.00



Packaging

Identify as per dwg & Stock Location: _____

Memo

0.00

Packaging

ID AND STOCK UNDER NEW BATCH NUMBER

10-3-5 (4x) SD

Work Order ID 56644

Wednesday, March 03, 2010 11:06:45 AM

Page 2

Item ID: D3224-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Frame

Start Date: 3/3/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 3/4/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

0.00



QC

Memo

0.00

Quality Control

10/03/05 *[Signature]*
MF
10-3-3

Date: Wednesday, 06/05/2009 8:45:54 AM
 User: Melanie Fauteux

Process Sheet

AOC

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FRAME
Job Number :	47759		
Estimate Number :	10300		
P.O. Number :		Part Number :	D32241
This Issue :	06/05/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3224 REV A
First Issue :	//	Project Number :	N/A
Previous Run :	44164	Drawing Revision :	A
	Type :	Material :	
	SMALL / MED FAB	Due Date :	06/05/2009
Written By :		Qty:	6
Checked & Approved By :	<u>YMF 09-05-06</u>	Um:	Each
Comment :	Est Rev:A New Issue 05-11-06 JLM		
	Est: B 06.11.15 waterjet EC		

REFERENCE ONLY

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 5.4600 sf(s)/Unit Total : 32.7600 sf(s)

2024-T3 .063 thick aluminum sheet

Batch: 110980 1B9-5-6

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3224

Dwg Rev: A 1B9-5-6

Prog Rev: A

2-Deburr if necessary 1B9-5-6

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

Date: Wednesday, 06/05/2009 8:45:54 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME

Job Number: 47759

Part Number: D32241

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3224

N/AB

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-05-05

ENCE ONLY

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005/41

09-05-06

Continue here

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPD

47766

8/5/05/06

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/06

Job Completion



09-05-06

Start time: 2:00
 Temp: 320°
 Finish time: 2:30

REFERENCE ONLY

Sb Powder Coat Black Saddle Qty 126 By

4 09/05/06 F.L.

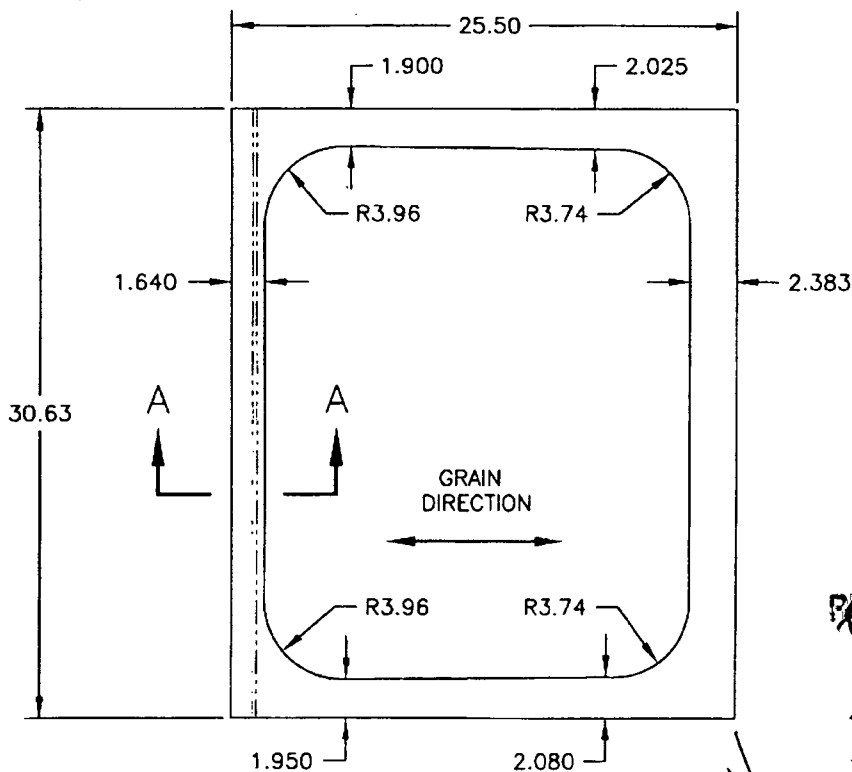
Boys

EC 23 'Insect Powder Coat' Qty 126 By 4 09/05/06 S 09/05/06

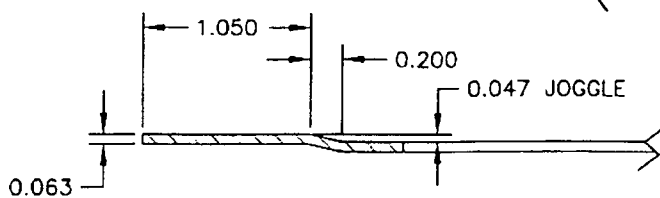


DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3224	REV. A SHEET 1 OF 1
DATE 03.10.21		TITLE FRAME	SCALE NTS
A	03.10.21	NEW ISSUE	

RELEASED
04 02 03



D3224-1



SECTION A-A
SCALE 8:1

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 2) MATERIAL: 2024-T3 (QQ-A-250/4), 0.063 THICK (REF. M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

REFERENCE ONLY

105th
28 1/2
23 1/2

DAVID IS WILLING
TO APPROVE THIS
MOD FOR
SPACECRAFT

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